Each

Dart Aerospace Ltd. Monday, 7/9/2007 11:46:45 AM Date: Kim Johnston User **Process Sheet** : PLUG : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer Job Number : 33349 : 10512 **Estimate Number** : D26511 JIA **Part Number** P.O. Number **Drawing Number** D2651 REV. B This Issue : N/A Prsht Rev. Project Number : MACHINED PARTS **Drawing Revision** First Issue : 33185 Material Previous Run : 7/16/2007 300 Um: **Due Date** Written By Checked & Approved By : Est: New Issue NG Comment .04.15 Est: added deburr EC B 05.12.12 Additional Product Job Number: Description: Seq. #: Machine Or Operation: M6061T6R0500 6061-T6 Round Bar .500' 1.0 Comment: Qty.: 0.0421 f(s)/Unit Total: 12.6315 f(s) Material: 6061-T6 (QQ-A-225/8) 0.500" Dia (M6061T6R0500) Batch: 11 002 061 20 Comment: HAAS CNC VERTICAL MACHINING #1 1- Turn as per Folio FA219 and Dwg D2651 2- Deburr QC2 INSPECT PARTS AS THE 3.0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 4.0 QC8 SECOND CHECK

SMALL & MEDIUM FAB RESOURCE 1

5.0

Comment: SECOND CHECK

SMALL FAB

Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr ias per dwg D2651

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP		PRO	CEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									•	
				•						
					-					
Part No);		PAR #:	Fault Category:	NCF	₹ : Yes	No DQ	A:	Date: _	7/08L3C
						QA:	N/C Close	d:	_ Date: _	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
-		Description of NC		Corrective Action Section B		Verification	Annroyal	Annewal		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approvàl QC Inspector		
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NOTE: Date & initial all entries

	ionday, 7/9/2007 11:46:45 AM im Johnston	Process Sheet		(tsmall)	
Custome	er: CU-DAR001 Dart Helicopters Service			<u> </u>	
Job Numbe	er: 33349	Part Num	nber: D26511		
Job Number:					
Seq. #:	Machine Or Operation:		Description :		
6.0	HAND FINISHING1	HAND FINISHING RESOL	JRCE #1		
Com	ment: HAND FINISHING RESOURCE Acid etch and Alodine as per Q	• A	02	· 08 - 2d -	(496)
7.0	POWDER COATING	POWDER COATING	<u> </u>	- 00 - 201 -	100
		M 105068	>		(446x)
Com	ment: POWDER COATING Powder Coat White Gloss (Ref:	4.3.5.1) as per QSI 005 4.3	/	-1	100
	(Only larger section necessary)		M-h	07/0	8/29
8.0	QC3	INSPECT POWDER COAT	T/CHEMICAL CONV	/ERSION	(9)
9.0	ment: INSPECT POWDER COAT PACKAGING 1	PACKAGING RESOURCE	<u> </u>	01/0	8/29
9.0	PACKAGING I	FAUNAGING RESOURCE	. #1		446X)
Com	ment: PACKAGING RESOURCE #1 Identify and Stock	,		/	
	Location:	- 15	Mr	k 07	1/68/29
10.0	QC21	FINAL INSPECTION/W/O	RELEASE		4976
Comi	ment: FINAL INSPECTION/W/O RELE	EASE		\rightarrow	A-108130
Job Completion				N 87.08.	30
					:
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				•	

Dart Ae	rospace L	td							
W/O:			V	ORK ORDER CHANGES					
DATE STEP		PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
							:		
Part No	:	PAR #:	Fault Cat	tegory: NC	R: Yes	No DQA :	:	_ Date: _	
					QA: N	/C Closed:		_ Date: _	
NCR:			WORK ORI	DER NON-CONFORMANCE	E (NCR	2)			
	0750	Description of NC		Corrective Action Section B		Verifica	tion	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
					:				
•						,		·	

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33349
Description: Plug	Part Number:	D2651-1
Inspection Dwg: D2651 Rev: B		Page 1 of 1

Inspection Dwg	j: D2651 Rev	: B				Page 1 of 1
	FIRS.	T ARTICLE II	NSPECTI	ON CH	ECKLIST	
	X	_		_	otype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.005	1000	-/			
0.375	+/-0.010	,375				
0.050 x 20°	+/-0.010	1050 × 70°	//			
Ø0.305	+0.000/-0.002	, 304				
Ø0.438	+/-0.005	,437				
0.060	+/-0.005	,061	/,			
0.090	+0.000/-0.002	60885				
0.045	+0.000/-0.002	044	./			
						7777
						APPROXIMATION CONTRACTOR OF THE PROPERTY OF TH
4						
						· · · · · · · · · · · · · · · · · · ·
			<u> </u>			
Measured by:	(40)	Audited by:	<u> </u>	F	Prototype Appro	
Date: 0	7 08 24	Date:	07/08/2		D	ate:

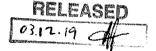
Measured by:	\mathcal{U}	Audited by:	Prototype Approval:	N/A
Date: 0	104/21	Date: 07/08/21	Date:	
Dott.	Change		Davised by	A

Rev	Date	Change	Revised by	Approved
Α	03.12.22	New Issue	KJ/RF	7

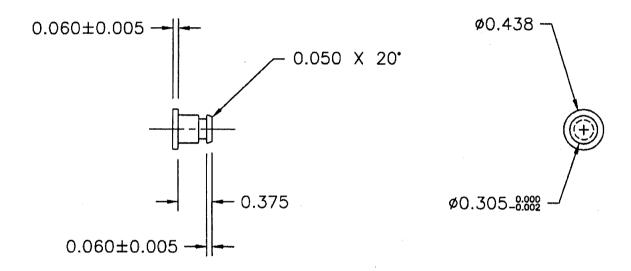




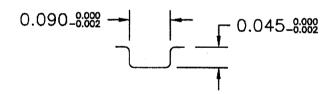
DESIGN DRAWN BY		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
CHEC	(ED	APPROVED	DRAWING NO.	REV. B				
	AF.	1 9#	D2651 SHEET	1 OF 1				
DATE			TITLE	SCALE				
 03.1	2.19		PLUG	1:1				
Α		97.03.25	NEW ISSUE					
В		03.12.19	ADD POWDER COAT, MS28775-008					



D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



D2651-1 PLUG

- MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHEWISE NOTED SHOP COPY
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

1) MATERIAL: BUNA N, 70 DUROMETER 3/16 ID, 5/16 OD, 1/16 WIDTH (PARKER 2-008, MS28775-008 OR EQUIVALENT)

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